

Date: Wednesday, 22/10/2008 4:08:42 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REAR RAIL
Job Number	: 42873		
Estimate Number	: 13494		
P.O. Number	:	Part Number	: D37663
This Issue	: 22/10/2008 S.O. No. :	Drawing Number	: D3766 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40865	Material	:
Written By	:	Due Date	: 07/11/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 08-10-22</u>		
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W
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Comment: Qty.: 2.9323 f(s)/Unit Total: 29.3234 f(s)
 6061T6 RD TUBE 1.00 X .188W
 batch:- M1109041

m.d 09/01/15

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

2-drill holes thru to finish size as per dwg D3766 using DT9413, Drill holes labelled #3.

3- deburr

FF 09/01/16

m.d 09/01/16

(10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/01/16 (x10)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

gld 09-01-20 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 4:08:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR RAIL

Job Number: 42873

Part Number: D37663

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 09.01.20 (10)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST246A

JS 09/01/20 (XG)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21 JS

Job Completion



U 09.01.20

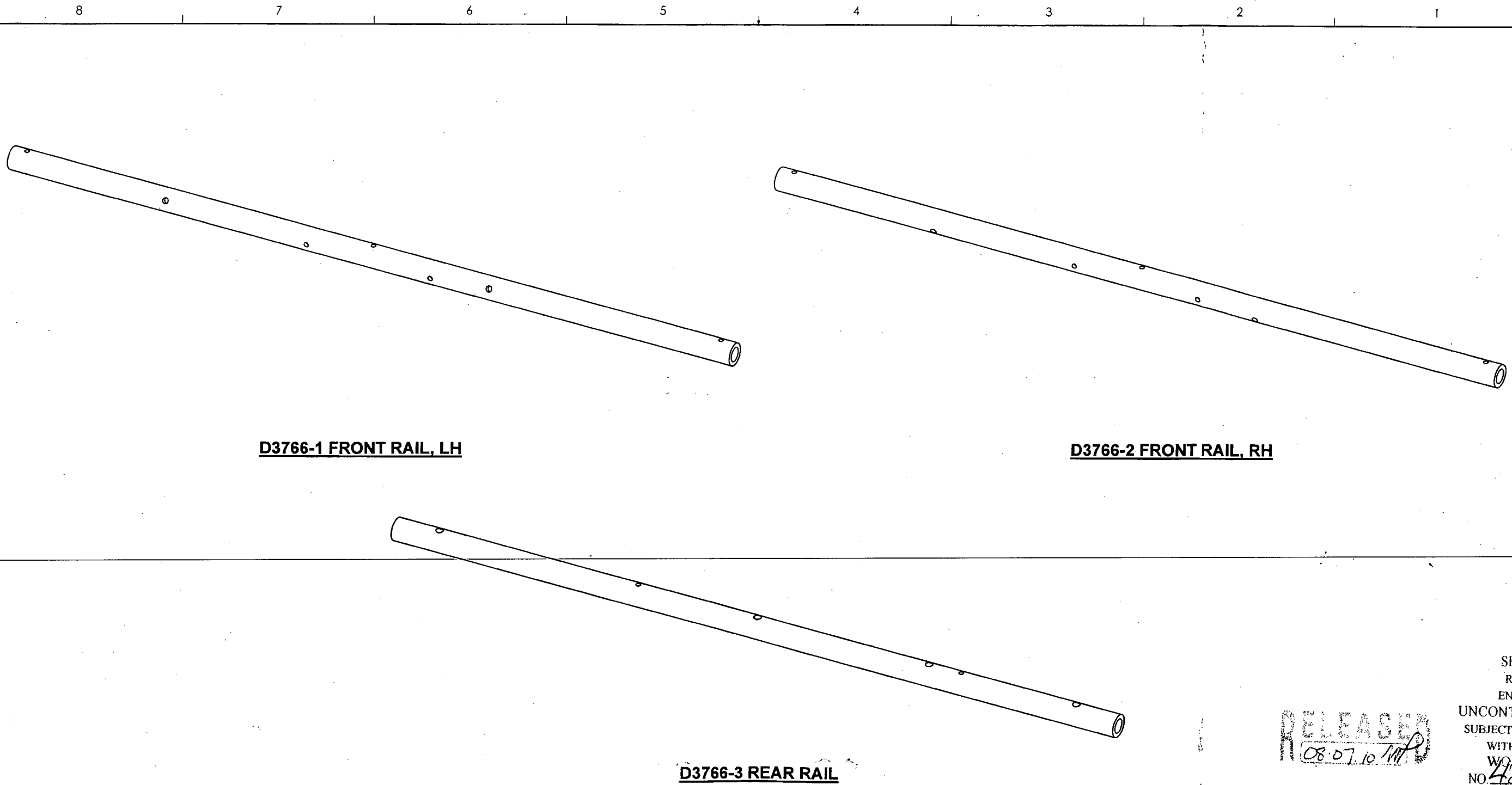
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

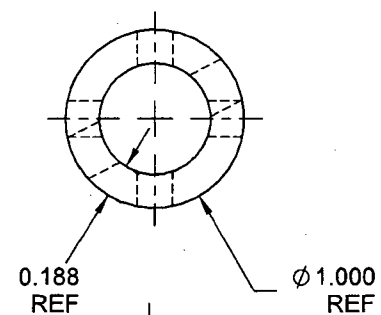
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08.07.10

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WORK ORDER
NO. 42873

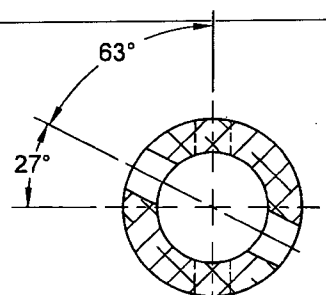
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

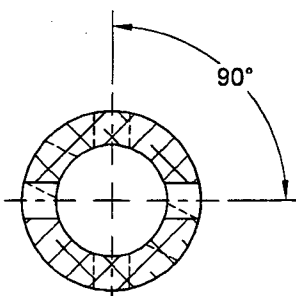
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3766	SHEET 1 OF 4
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DE APPR.		RAIL	NTS
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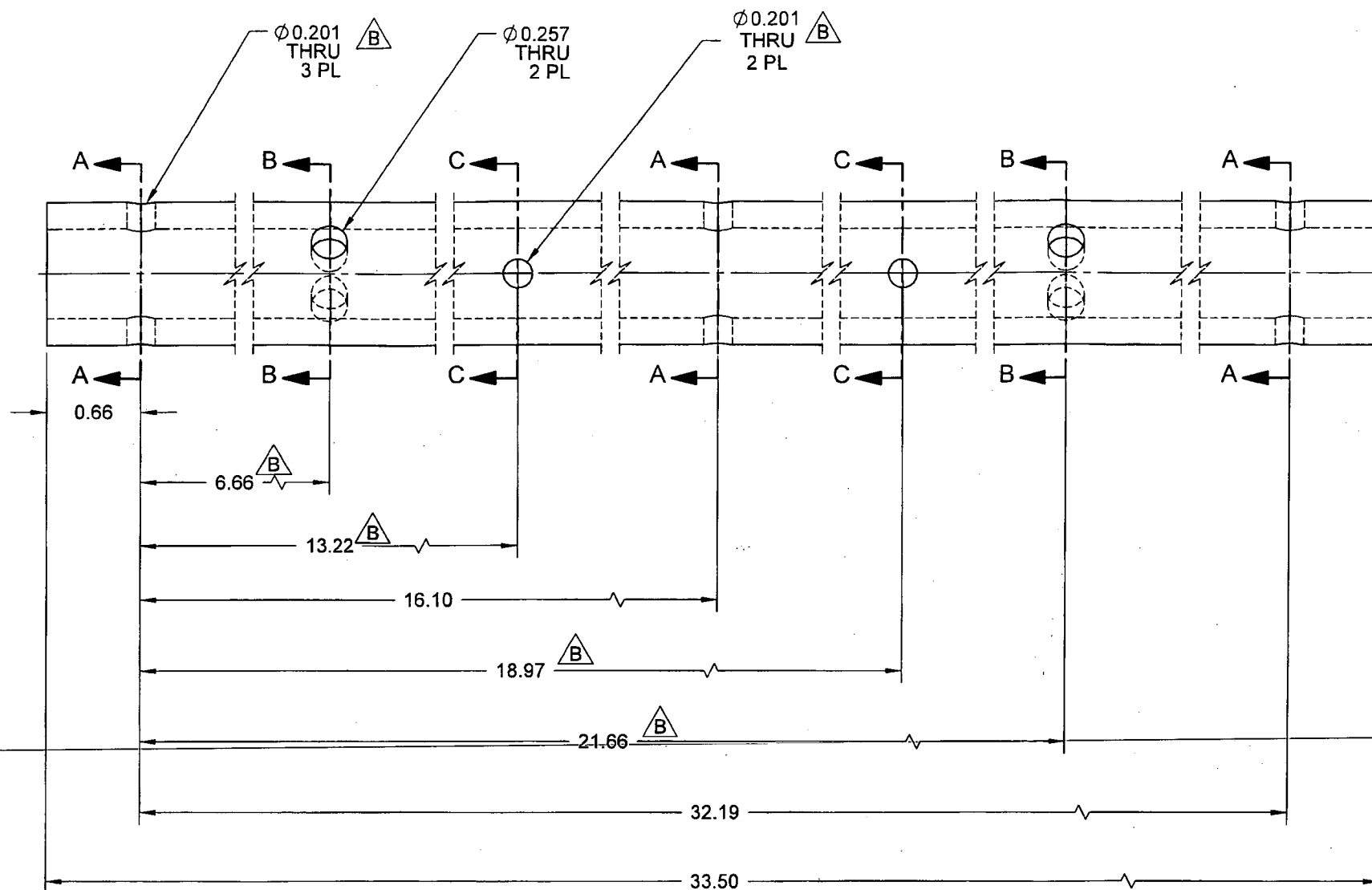
SECTION A-A



SECTION B-B



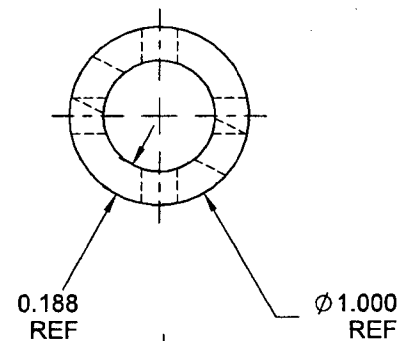
SECTION C-C



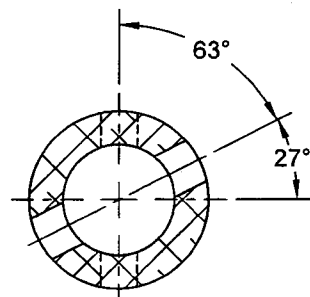
D3766-1 FRONT RAIL, LH

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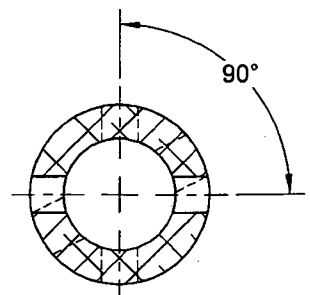
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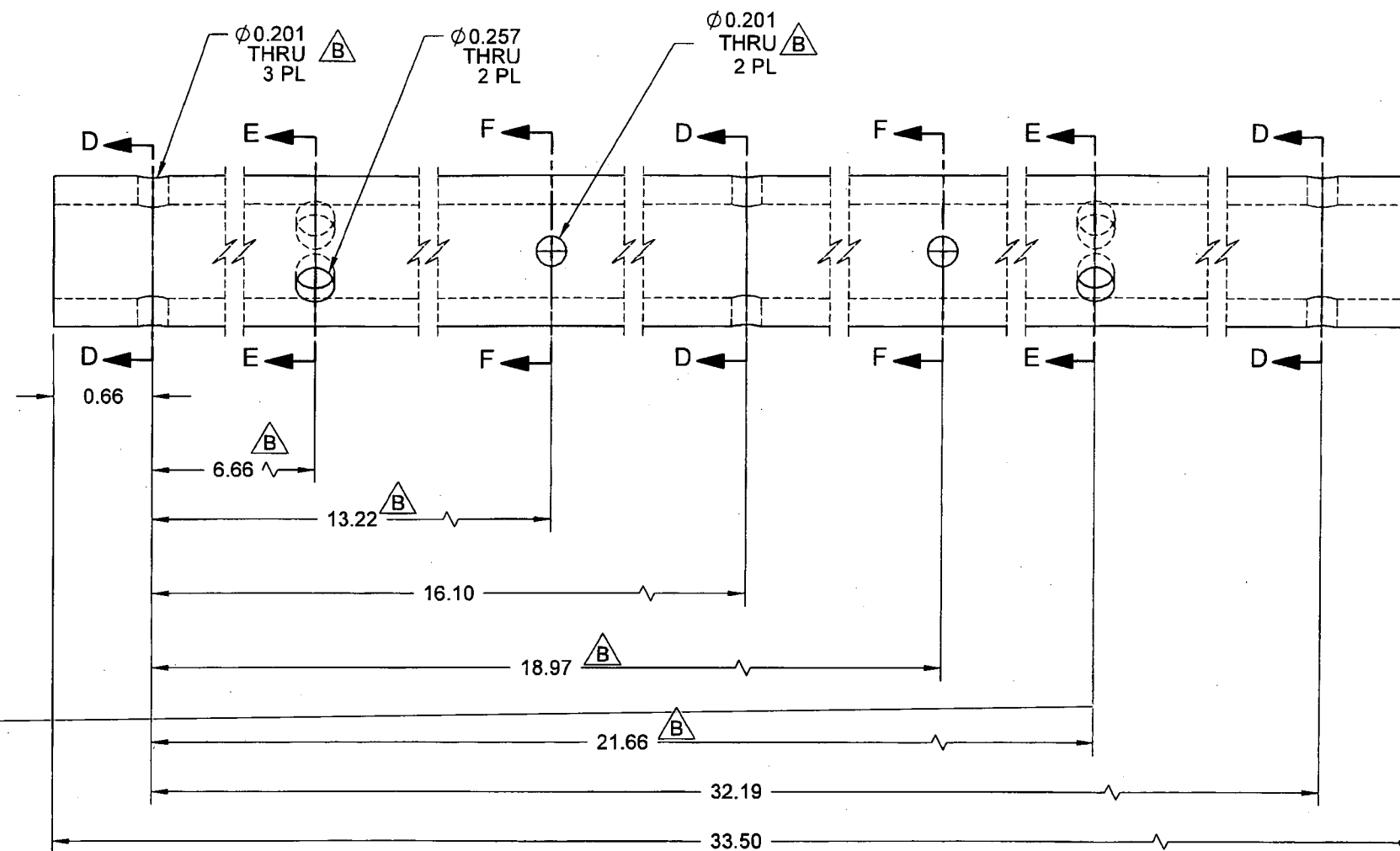
SECTION D-D



SECTION E-E







SECTION F-F



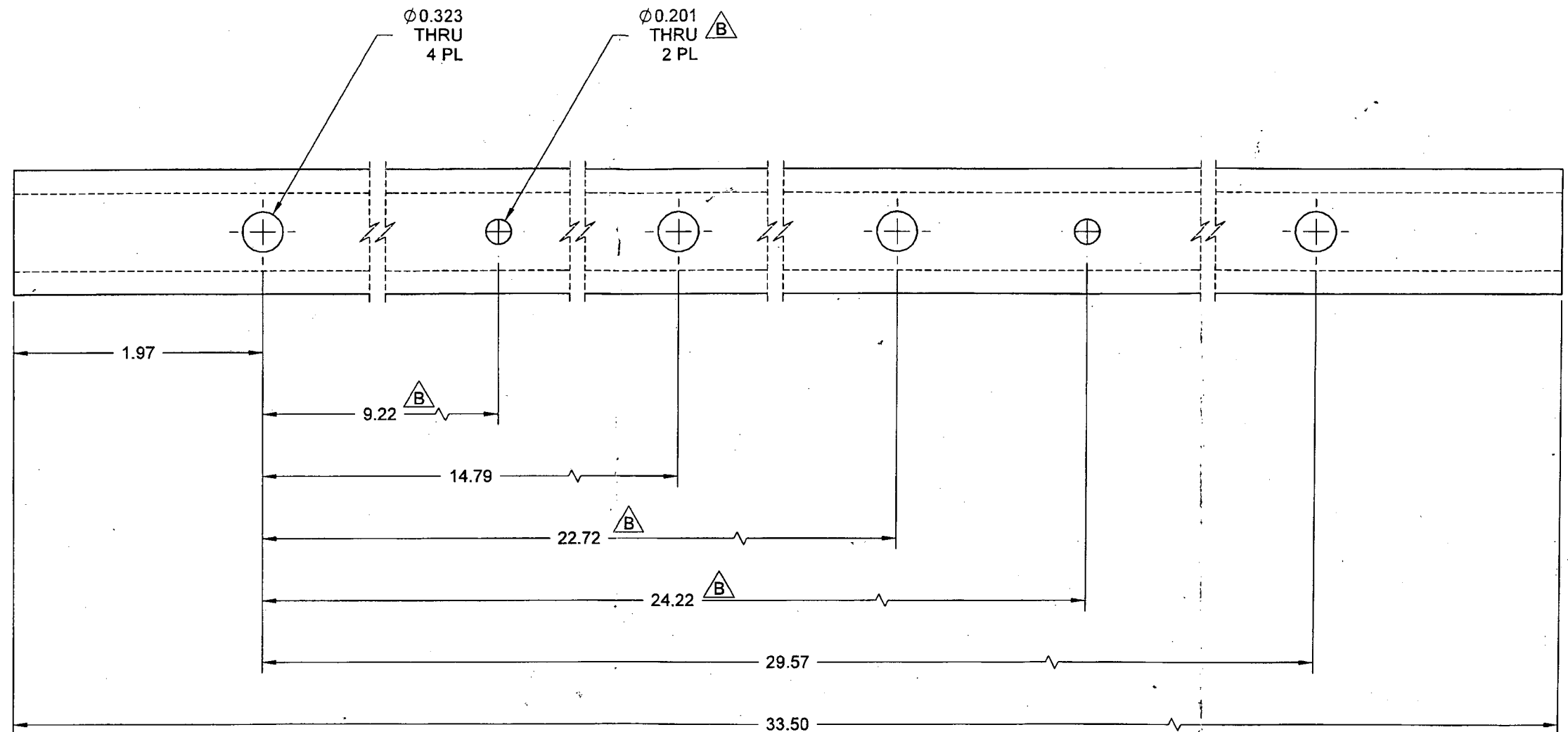
D3766-2 FRONT RAIL, RH

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0.188
REF

Ø1.000
REF



D3766-3 REAR RAIL

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WORK ORDER
NO. 42873

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